



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-760-113
Job Sheet 171895



Part No: D412-760-113

Job Qty: 1 ea

Part Name: Aft Cabin Wall & Pylon Protectors



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEET 42 IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/23/18	0.00	0.00	Start Up Stores/Pkg-1		FEB 22 2018
110	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging1-4		FEB 22 2018
120	QC	DAS pcs		2/23/18	0.00	0.00	QC4		Smb
125	DC	35 pcs		2/23/18	0.00	0.00	DC		
130	Packaging	9-89 pcs		2/23/18	0.00	0.00	Packaging3-2		Smb
140	QC21-FG	1 Ea		2/23/18	0.00	0.00	QC21		FEB 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3933-1	Aft Wall Protector	1 Ea (1 ea)	90-Start up Operation	
D3933-2	Aft Wall Protector, RH	1 Ea (1 ea)	90-Start up Operation	
D3935-3	Pylon Wall	1 Ea (1 ea)	90-Start up Operation	
D3935-4	Pylon Wall	1 Ea (1 ea)	90-Start up Operation	
D3942-1	Angle	14 Ea (14 ea)	90-Start up Operation	
D3942-3	Clip	10 Ea (10 ea)	90-Start up Operation	
MS27039-4-10	Screw	4 Ea (4 ea)	90-Start up Operation	
MS27039-4-14	Screw	6 pcs (6 ea)	90-Start up Operation	
MS27039-5-08	Screw	6 Ea (6 ea)	90-Start up Operation	
MS27039-5-12	Screw	8 Ea (8 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3933-1	1	1	0
	D3933-2	1	1	0
	D3935-3	1	1	0
	D3935-4	1	1	0
	D3942-1	14	20	0
	D3942-3	10	15	0
	MS27039-4-10	4	76	0
	MS27039-4-14	6	76	0
	MS27039-5-08	6	1	0
	MS27039-5-12	8	18	0

007110

Part Specifications

DEA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By _____ hand / Supervisor Approval Verification _____ QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Date: 02/22/18 Contained Wrong Side Dimensions /Under tolerance Incorrect Lost/Missing Moved ving ,h Misread Turning Sequence					
Design ☐	Operator ☐	Bending ☐	Set-up ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Container No: S044546
 Part: D412-760-113
 Job No: 171895
 Serial No/Batch: S044546
 Revision: IIN D412-760
 Inspector:

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 Hawkesbury, ON K6A 1K7
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 Email: sales@dartaero.com
 www.dartaerospace.com

Specifications could not be found.

Plex 2/9/18 8:00 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 001110

Tel (613) 632-5200

Containers on Master Unit 001110				
Serial No	Part No	Customer Part No	Status	Quantity
S038407	D3933-1		Allocated	1
S038396	D3933-2	D3933-2	Allocated	1
S038417	D3935-3		Allocated	1
S038440	D3935-4		Allocated	1
S044545	D3942-1		Allocated	14
S044544	D3942-3		Allocated	10
S044537	MS27039-4-10		Allocated	4
S044536	MS27039-4-14		Allocated	6
FM135359	MS27039-5-08		Allocated	1
S044535	MS27039-5-08		Allocated	5
S044534	MS27039-5-12		Allocated	8

Change Record

Part Number D412-760-113
Description AFT CABIN WALL & PYLON PROTECTOR

Page 1 of 1[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-760

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Qty -111	Qty -113	Part Number	Description
X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	1	D3935-4	RH PYLON PROTECTOR
14	14	D3942-1	ANGLE
10	10	D3942-3	CLIP
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty -211	Qty -213	Qty -215	Qty -217	Part Number	Description
X				D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			X	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
36	7	8		D3628-1	CUPPED WASHER
			43	D3628-5	CUPPED WASHER
1				D3876-1	RH FORWARD WALL PROTECTOR
1				D3876-3	FORWARD WALL PROTECTOR
1				D3876-5	LH WALL PROTECTOR
1				D3876-7	AFT WALL PROTECTOR
1				D3876-9	RH AFT WALL PROTECTOR
1		1		D3876-11	FLOOR PROTECTOR
1				D3876-13	DOOR PROTECTOR
1		1		D3952-1	PLACARD
			1	D3952-3	PLACARD
	1			D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
			1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
36		8	36	80-004-2-6	INSERT
	7		7	80-004-2-8	INSERT
36		8	36	MS27039-1-04	SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

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Date: 13.01.03